

Slip Oct. 3

Dart Aerospace Ltd.

split w/o  
SBS 07/10/03

Date: Monday, 10/1/2007 1:37:22 PM  
User: Kim Johnston

### Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 34919		
Estimate Number	: 12172		
P.O. Number	: N/A	Part Number	: D2066
This Issue	: 10/1/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2066 REV B
First Issue	: N/A	Project Number	: N/A
Previous Run	: N/A	Drawing Revision	: B
		Material	: N/A
Written By	: <u>HA</u>	Due Date	: 10/8/2007
Checked & Approved By	: <u>HA 07.10.01</u>	Qty:	3 Um: Each
Comment	: Est. B 02.03.18 Added pick list NG		

#### Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TR0500W035 304 RD Tube .500 x .035W



Comment: Qty.: 2.5043 f(s)/Unit Total: 7.5128 f(s)  
304 RD Tube .500 x .035W  
Punch 1/2" OD x .035" Wall 304/316 SS Seamless Tube  
(Ref QSI 017 4.1.1.2) as per Dwg D2066  
Use punch Jig DT8012  
Batch: H105575

mf 07-11-14

2.0 D2052 Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)  
Bracket  
Pick:  
Qty Part number Description Batch  
2 D2052 Bracket B17214

SBS

3.0 D2055 Clamp



Comment: Qty.: 2.0000 Each(s)/Unit Total: 6.0000 Each(s)  
Clamp 1.0  
Pick:  
Qty Part number Description Batch  
1 D2055 Clamp B28823

SBS

4.0 D2056 Bell Crank Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)  
Bell Crank Assembly  
Pick:  
Qty Part number Description Batch  
1 D2056 Bellcrank B17049

SBS 07/11/14



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/10/03	6	Split w/o balance of 3 pieces	SB	07/10/03	④			
07/10/03	6	Keep 1 for Template hole off tolerance	SB	07/10/03	①			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34919

Part Number: D2066

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2054

Bushing - Delrin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Bushing - Delrin

Pick:

Qty	Part number	Description	Batch
2	D2054	Bushing	B16711

SB 07/11/14 (3)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Slide on parts per Dwg and W/O for D2676-043

Punch other end to length (28.62") as per Dwg D2066

Bend per Dwg D2066

Drill 3/16" Dia holes per Dwg D2066

Deburr

mf 07-11-14 (3)  
mf 07-10-03

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-11-15 (3)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

N/A - R

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Record D2066 Batch number on W/o for D2676-043

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 08/11/15  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 34919

Part Number: D2066

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

57239 AS

07/11/15

12.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

07/11/15

Job Completion



12 07-11-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

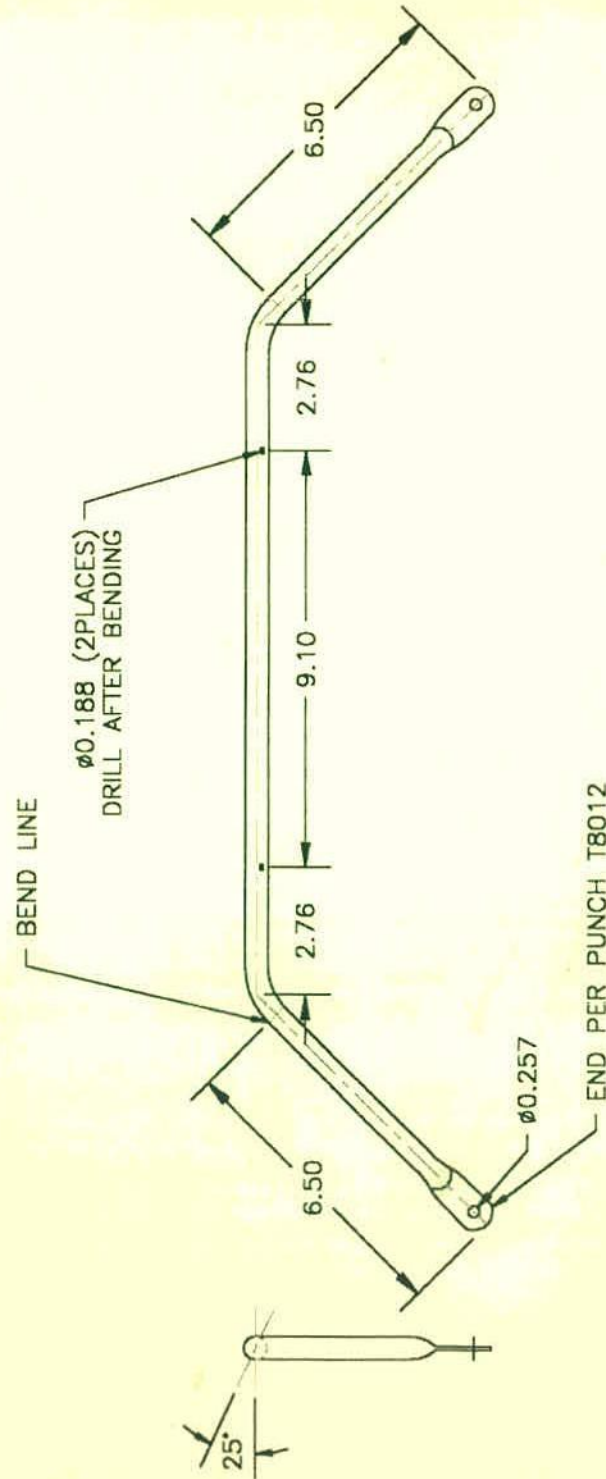
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED <i>BW</i>	APPROVED <i>JS</i>	D2066	SHEET 1 OF 1
DATE	TITLE	SCALE	
92.03.12	ARM	1:4	
B	96.02.06	RE-DESIGNED	



D2066 CUT LENGTH 28.62  
NOTE:  
ADD D2052,D2055,D2056  
D2054 TO ARM BEFORE  
ENDS ARE PUNCHED AND  
ARM IS BENT

MATERIAL: 304/316 SS 1/2 OD X 0.035 WALL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34919





REFERENCE ONLY

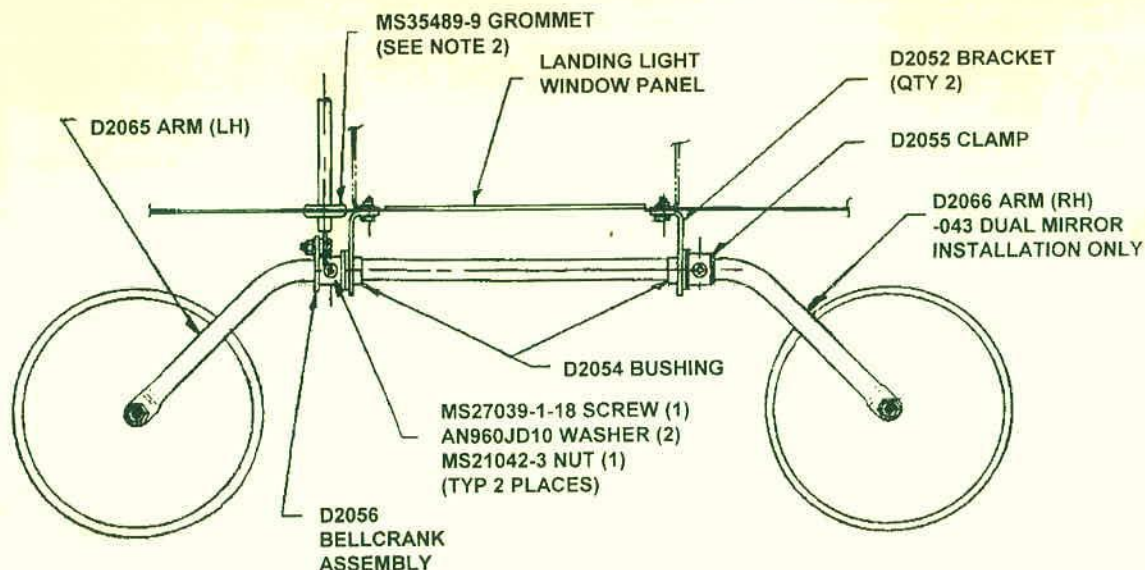


Figure 25.2 – View A: Looking Aft.  
(D206-558-043 Mirror Shown)

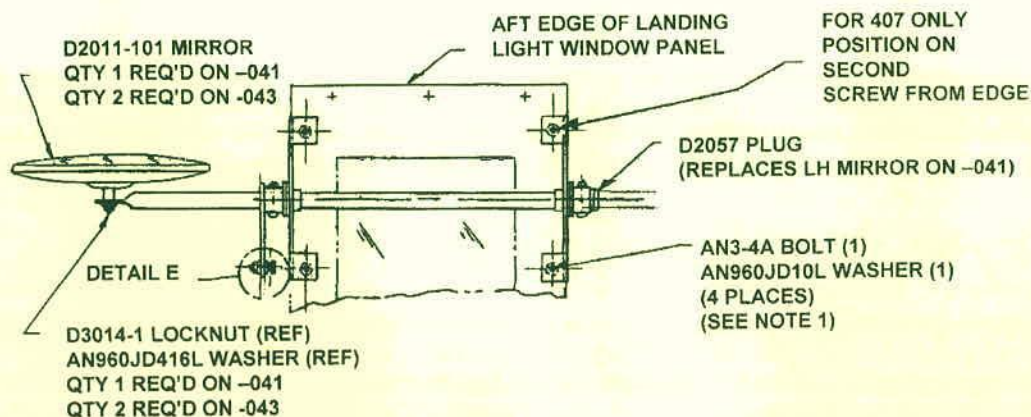


Figure 25.3 – View C: Looking Down on Mirror Installation  
(D206-558-041 Mirror Shown)

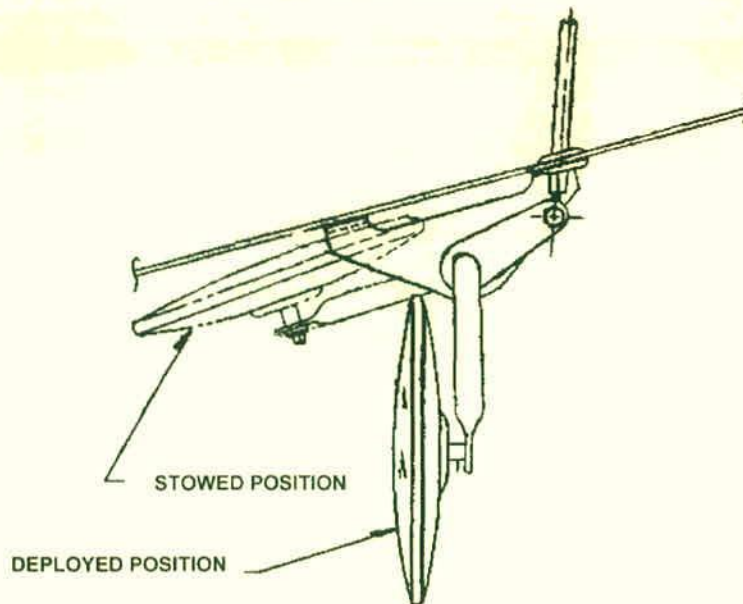
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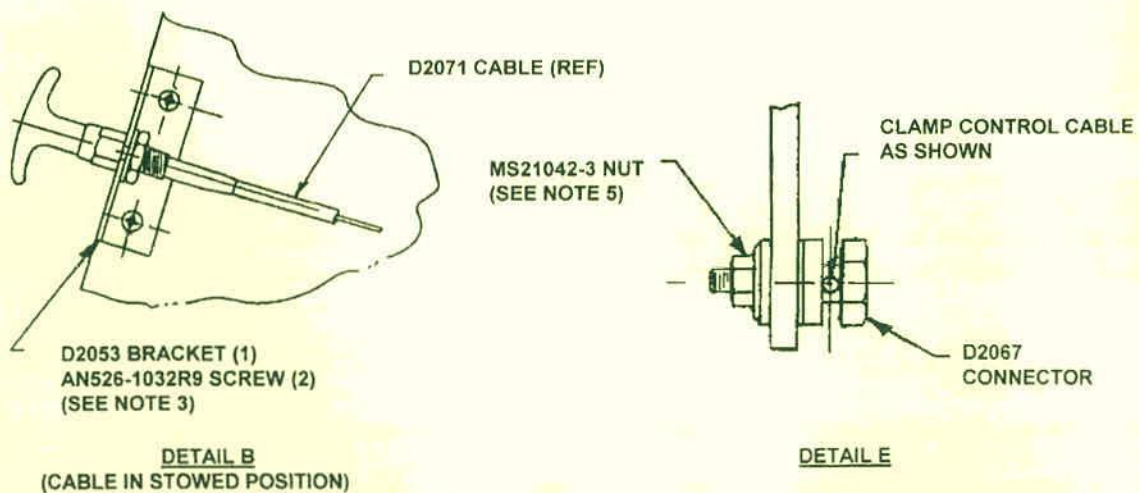




**REFERENCE ONLY**



*Figure 25.4 – Detail D: Looking from Side on Mirror Installation  
(D206-558-041/-043 Mirror Shown)*



*Figure 25.5 – Details B and E on Mirror Installation  
(D206-558-041/-043 Mirror Shown)*

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